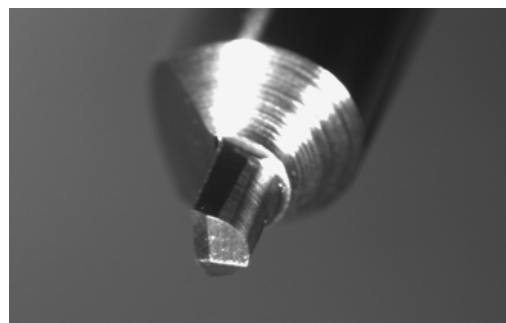
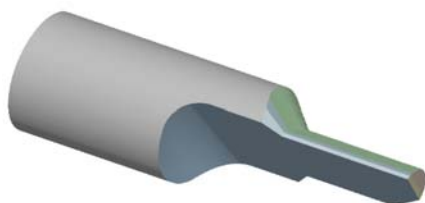



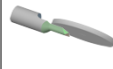
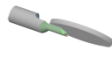



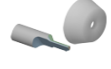
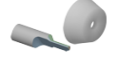
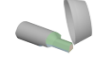








Straight micro Endmill Ø1.1, Z1

A1-011

The cutting quality of straight micro milling cutters depends on the surface roughness of the contact surfaces. Oscillating polishing operations on cutting face, OD and end are available.



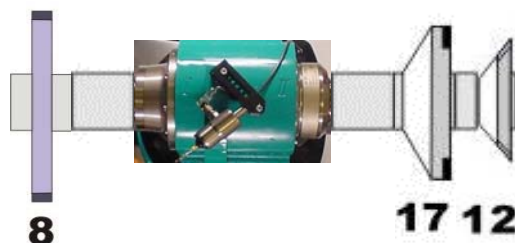
1. Cycletime for Production

Tool specifications Ø1.1, Z1, Length 7 mm Material CARBIDE									
Operations									
Feed [mm/Min]	2000	30	150	200	70	100	100	100	100
Power [kW]		4	2	1	1	1	1	1	1
Cutting feed [m/s]		22	24	24	24	24	24	24	24
Used wheels									
Grinding time [s]	8	30	24	117	19	52	26	11	11
Total cycle time	4 Min 57								

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

17 Ø125 12A2 D64
12 Ø100 12V9 D16
8 Ø125 1A1 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG
Control: Fanuc 31i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 5

responsible engineer: OP,11.9.07

www.schneeberger.ch

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